



Dart Aerospace Ltd.
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D2563
Job Sheet 186744



Part No: D2563

Job Qty: 1 ea

Part Name: Step Weldment Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/18

Job Tracking No:

Due Date: 11/28/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C IPP Rev:G 02.07.31 Re-format Location RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/28/18	0.00	0.00	Start Up Large Fab-2		SLU
100	Large Fab	1 pcs		11/28/18	0.00	1.47	Large Fab 2		SLU
110	QC	1 pcs		11/28/18	0.00	0.00	QC9		CPC
120	QC	1 pcs		11/28/18	0.00	0.00	QC5		CPC
130	HandFinish	1 pcs		11/28/18	0.00	0.27	HandFinish1		D.R. 18/11/21
140	QC	1 pcs		11/28/18	0.00	0.00	QC7		CPC
150	Large Fab	1 pcs		11/28/18	0.00	1.47	Large Fab 2		SLU
160	QC	1 pcs		11/28/18	0.00	0.00	QC10		CPC
170	QC	1 pcs		11/28/18	0.00	0.00	QC5		CPC
175	HandFinish	1 pcs		11/28/18	0.00	0.27	HandFinish2		D.R. 18/11/26
180	Powdercoat	1 pcs		11/28/18	0.00	0.17	Powdercoat1		DEB 18-11-26
190	HandFinish	1 pcs		11/28/18	0.00	0.27	HandFinish3		DEB 18-11-26
200	QC	1 pcs		11/28/18	0.00	0.00	QC3	DAS	NOV 27 2018 68
210	Packaging	1 pcs		11/28/18	0.00	0.00	Packaging3	69	DEC 11 2018 9-89
220	QC21-SA	1 Ea		11/28/18	0.00	0.00	QC21	9-89	21

Part Op 100 - 1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 2-Deburr ends 3-Weld (1 END CAP, LUG PLATES & Descriptions: MOUNTING ANGLE) as per dwg D2563 using DT 8343 4- Grind
150 - 1-Inspect for foreign object per QSI 024 2-Weld Remaining End cap as per Dwg D2563 using DT 8343 3-Grind
175 - Touch up Alodine as per QSI005
M138951 180 - Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 14:50
TEMP: 320° FINISH: 12:20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2244-116	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	B164523-75
D2561	Lug	2 Ea (2 ea)	90-Start up Operation	5122010
D2564	Mounting Angle	2 Ea (2 ea)	90-Start up Operation	9124417
D2673-34	End Plate	1 Ea (1 ea)	90-Start up Operation	9063804
D2673-34	End Plate	1 Ea (1 ea)	150-Large Fab	5078838

M138963 wing walk

6501

1

36
1950

80
1950

1

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2244-116	1	245	0
	D2561	2	16	0
	D2564	2	44	0
	D2673-34	1	23	0
150-Large Fab	D2673-34	1	23	0
Part Specifications				
Specifications could not be found.				

Plex 11/21/18 7:32 AM dart.lacelle.linda



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Container No: S129814



Part: D2563

Job No: 186744

Serial No/Batch: S129814

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/21/18